

Claims

1. A coated cutting tool insert of cemented carbide with a coating including at least one layer of $Ti_{1-x}Al_xN$ deposited by PVD-technique characterised in that $x=0.4-0.6$ with a compressive residual stress of $>4-6$ GPa and a thickness of 1.5-5, preferably 2.5-4, μm ; both the intensities of the (111) and (200) reflections, I(111) and I(200), are <7.5 , preferably <5 times, the intensity average noise level.
- 10 2. Method of making a coated cutting tool insert of cemented carbide with a coating including at least one layer of $Ti_{1-x}Al_xN$ deposited by PVD-technique characterised in depositing the layer with a bias, U, in the range $-90 < U < -50V$, preferably $-80V < U < -60V$; with a nitrogen pressure in the range of 20-40 μbar ; arc current in the range 160-220 A and temperature in the range 400-600 °C.